

Date: Thursday, 29/05/2008 1:51:13 PM
 User: Melanie Fauteux

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: WEAR PLATE		
Job Number	39578			Part Number	: D2348		
Estimate Number	11231			Drawing Number	: D2348 REV B2		
P.O. Number	:			Project Number	: N/A		
This Issue	29/05/2008 S.O. No. :			Drawing Revision	: B2		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 05/06/2008 Qty: 50 Um: Each		
Previous Run	: 38811						
Written By	: <u>Mf 08-05-29</u>						
Checked & Approved By							
Comment	: Est Rev A Removed from 9 Digit 05-12-05 JLM Est Rev:B Now on Waterjet 06-07-03 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S063	6061-T6 .063 Sheet 1.4
Comment:	Qty.: 0.0208 sf(s)/Unit Total : 1.0395 sf(s)	
Material:	6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063)	
Batch:	<u>107387</u> <u>FB 8-5-30</u>	
2.0	WATER JET	FLOW WATER JET
Comment:	FLOW WATER JET	
1-Cut as per Dwg D2348		
Dwg Rev:	<u>B2</u>	
Prog Rev:	<u>B2</u> FB 8-5-30	
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK <i>S 0805130 X62 counts</i>
Comment:	SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment:	SMALL & MEDIUM FAB RESOURCE 1	
	Deburr	
		<i>E 0805130 62</i>

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/30 +62 counter

7.0 OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting PURCHASING

Issue P/O: 6520

C 08/06/04

(62)

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

L 08/06/19

(62)

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

INSPECT CERTS

S 08/06/20

(62)

10.0 FE832EF

PEM Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 FE832EF PEM Insert

M1082A4 x100

1108313 x100

M1082A4 x 148.

88

= 8/06/23 (x50)

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Insert as per Dwg D2348

J 08/06/23

(62)

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/23

(62)

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Seq. #: Machine Or Operation:

Description :

13.0 PACKAGING 1

PACKAGING RESOURCE #1



62x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 27

8/6/23

SCD

14.0 QC21

FINAL INSPECTION/W/O RELEASE



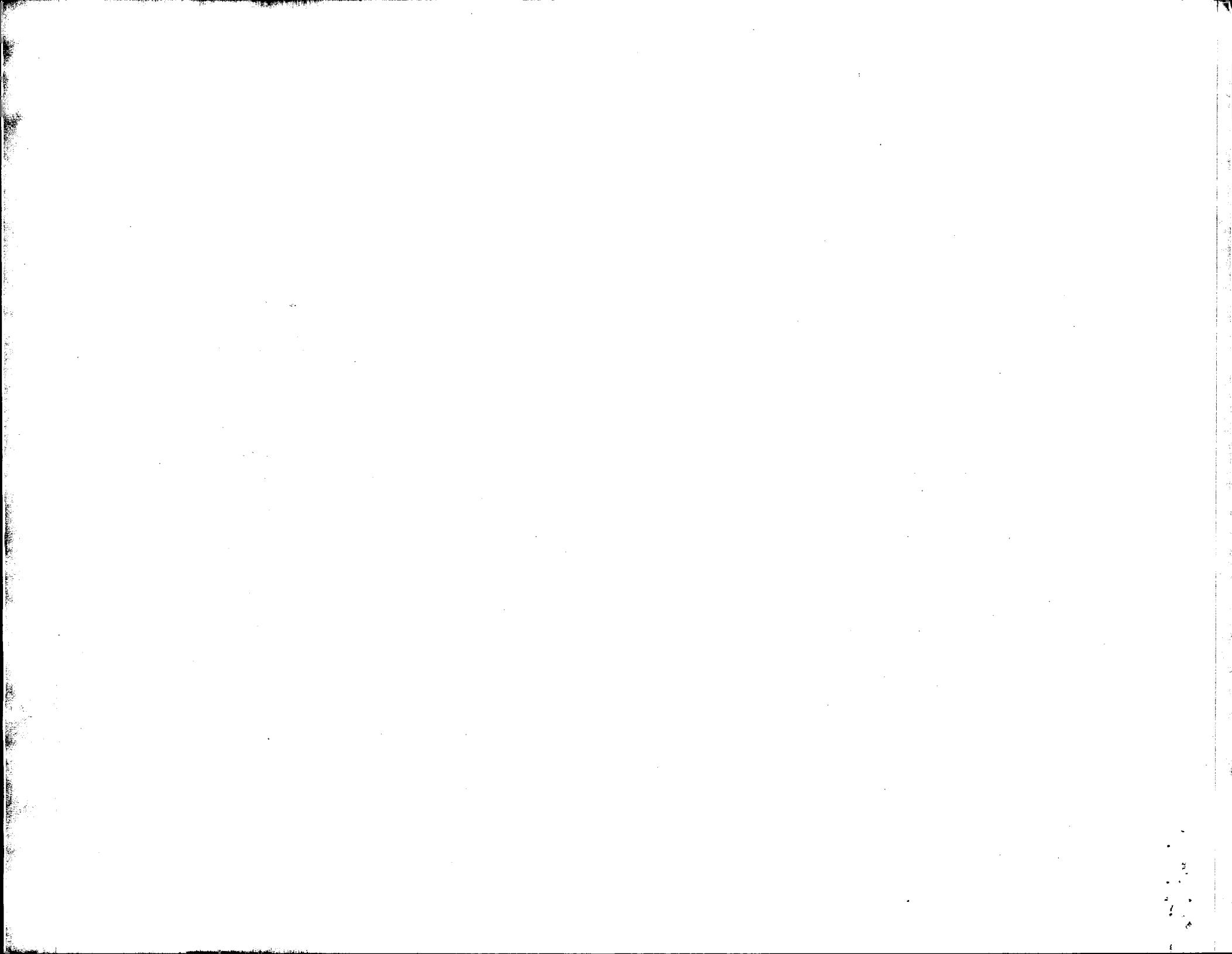
08/06/25 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-06-25

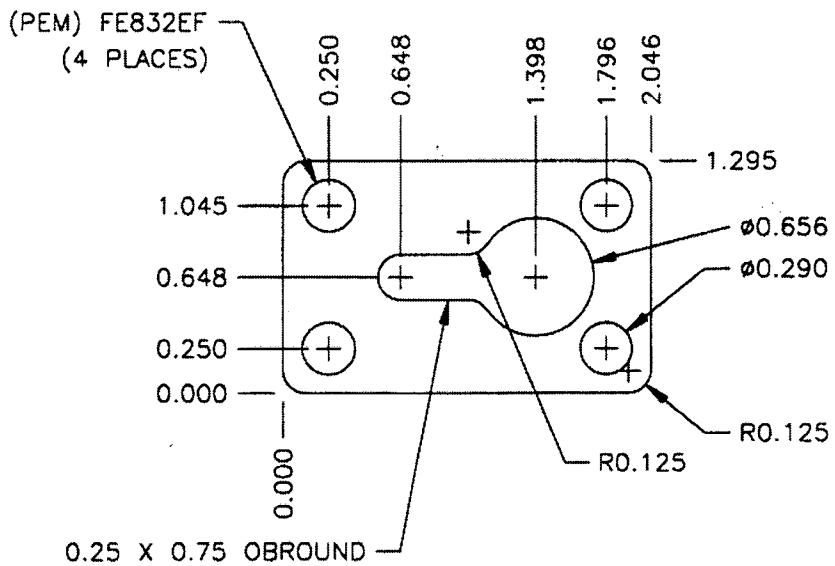




DO COPY
DRAFT

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>S</i>	DRAWING NO. D2348	REV. B SHEET 1 OF 1
DATE 95:01:20		TITLE WEAR PLATE	SCALE 1:1
B	95:02:20	CHANGED PEM INSERT TO 8-32	
B1	00.03.07	CHANGE TO AISI 304/316 MATERIAL	
B2	02.02.21	CHANGE BACK TO 6061-T6	

RELEASED
97/04/22 DS



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 (M6061T6S)
- 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/II/IC/II/IIIB CLASS 2
- 3) INSTALL FE832 EF INSERTS AFTER ANODIZING
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER PART QSF 0.08 UNLESS OTHERWISE NOTED.

B 39578

~~AISI 304/316 SS~~
MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK
~~AFTER ANODIZING INSTALL (PEM FE832EF) 4 PLACES~~

DART AEROSPACE LTD	Work Order:	39578
Description: WEAR PLATE	Part Number:	D2348
Inspection Dwg: D2348 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article | Prototype

Measured by:	JB	Audited by:	C	Prototype Approval:	n/a
Date:	8-5-30	Date:	08/05/30	Date:	8/5/30

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified
approuvé NADCAP approved**C. OF C**

65597

11-Jun-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY . ONTARIO
K6A 1K7**CERTIFICATE OF COMPLIANCE**
CERTIFICAT DE CONFORMITE**NO. DE COMMANDE:**
PURCHASE ORDER/

6520



ITEM ORDERED	COMMANDÉ EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	7	7 412-200-002-006 B39	DWG: D41232-200-002 REV. A
4	8	8 D3299-1 B38451	BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2399 REV. B
2	62	62 D2348 B39578	BLUE ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2348 REV. B2
3	62	62 D2348 B39666	BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2348 REV. B2
			BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2

Last Modified on 20-Jun-2008

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager